

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018681**Date Inspected:** 14-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of weld joint SEG068A-045 at locations outside PCMK OBG 11BE/11CE, side plate to bottom plate, north (crossbeam) side. See photo below. Welders were identified as 044515, 067752. QC was identified as ZPMC CWI Liu Hua Jie (QC1). Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-1 as displayed on ZPMC Weld Repair Report B-CWR2216 presented to this QA Inspector and verbally identified by QC1. QC1 informed this QA Inspector that this welding was being performed to correct indications as a result of ZPMC ultrasonic testing. ZPMC Weld Repair Report B-CWR2216 referred to ZPMC NDT Report UT-11E-049R1 (pre 48).

SMAW repair welding of weld joint SEG068A-044 located outside PCMK OBG 11BE/11CE, side plate to bottom plate, south (bikepath) side. Welder was identified as 053871. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-1 as displayed on ZPMC Weld Repair Report B-CWR2217 presented to this QA Inspector and verbally identified by QC1. QC1 informed this QA Inspector that this welding was being performed to correct indications as a result of ZPMC ultrasonic testing. ZPMC Weld Repair Report B-CWR2217 referred to ZPMC NDT Report UT-11E-048R1 (pre 48).

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ZPMC personnel performing bolt tightening using an air driven impact gun in OBG segment 11DE between panel point 105 and panel point 106 on side plate T-rib flange to side plate T-rib flange, north (crossbeam) side.

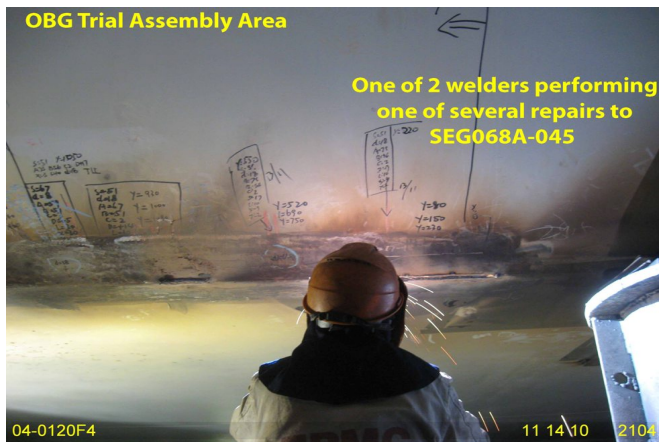
Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base pedestal at end of the Heavy Dock. All four towers, lift 5 were positioned on top of the respective lift 4. The ZPMC 1600 ton floating crane was moored near the head of the Heavy Dock and sitting idle.

OBG segment 10E was positioned on the deck of the ship moored to the end of the Heavy Dock. OBG segment 10W was positioned on top of OBG segment 10E. All four towers, lift 3 were positioned horizontally on the deck of the ship. OBG CB 13 and CB14 were positioned on the deck of the ship. ZPMC personnel were loading various bridge parts onto the ship using truck-mounted hydraulic cranes. Various welding work was observed being performed on stanchions and tie-downs only.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
